

## **Guidelines For The Slaughter Of Animals for Human Consumption**

### **Article 1**

#### **General principles for slaughter**

These guidelines address the need to ensure the welfare of food animals during pre-slaughter and slaughter processes, until they are dead.

These guidelines apply to those domestic animals commonly slaughtered in slaughterhouses, that is: cattle, buffalo, sheep, goats, deer, horses, pigs, ratites and poultry. Other animals, wherever they have been reared, should be managed to ensure that their transport, lairaging, restraint and slaughter is carried out without causing undue stress to the animals; the principles underpinning these guidelines apply also to these animals.

#### **Personnel**

Persons engaged in the unloading, moving, lairaging, care, restraining, stunning, slaughter and bleeding of animals play an important role in the welfare of those animals. For this reason, there should be a sufficient number of personnel, who should be patient, considerate, competent and familiar with the guidelines in this document and their application within the national context

The management of the slaughterhouse and the *Veterinary Services* should ensure that slaughterhouse staff carry out their tasks in accordance with the principles of animal welfare.

#### **Animal behaviour**

Animal handlers should be experienced and competent in handling and moving farm livestock, and understand the behaviour patterns of animals and the underlying principles necessary to carry out their tasks.

The behaviour of individual animals or groups of animals will vary, depending on their breed, sex, temperament and age and the way in which they have been reared and handled. Despite these differences, the following behaviour patterns which are always present to some degree in domestic animals, should be taken into consideration in handling and moving the animals.

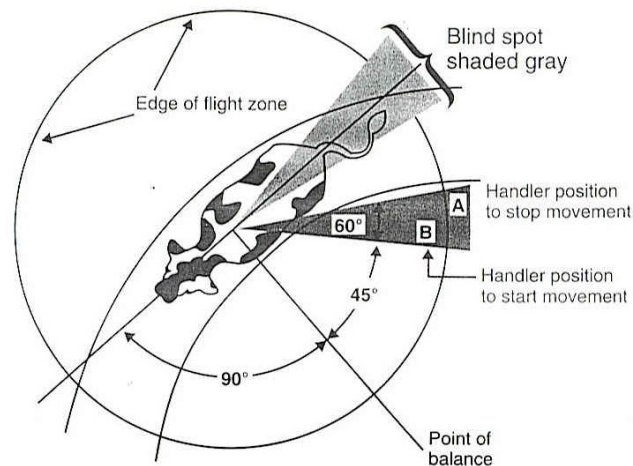
Most domestic livestock are kept in herds and follow a leader by instinct.

Animals which are likely to be hostile to each other in a group situation should not be mixed at slaughterhouses.

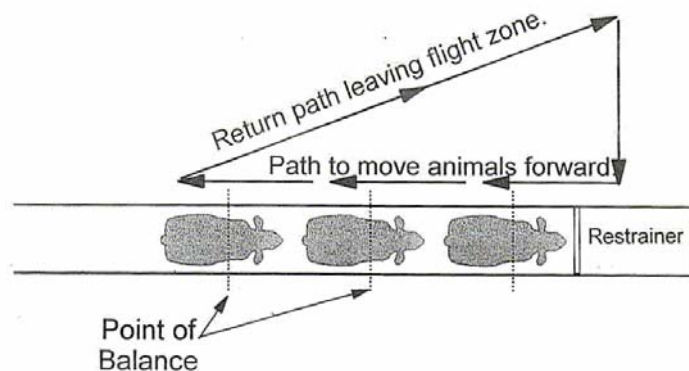
The desire of some animals to control their personal space should be taken into account in designing facilities.

Domestic animals will try to escape if an animal handler approaches closer than a certain distance. This critical distance, which defines the flight zone, varies among species and individuals of the same species, and depends upon previous contact with humans. Animals reared in close proximity to humans i.e. tame have no flight zone, whereas those kept in free range or extensive systems may have flight zones which may vary from one metre to many metres. Animal handlers should avoid sudden penetration of the flight zone which may cause a panic reaction which could lead to aggression or attempted escape.

**An example of a flight zone (cattle)**



**Handler movement pattern to move cattle forward**



Animal handlers should use the point of balance at an animal's shoulder to move animals, adopting a position behind the point of balance to move an animal forward and in front of the point of balance to move it backward.

Domestic animals have wide-angle vision but only have limited forward binocular vision and poor perception of depth. This means that they can detect objects and movements beside and behind them, but can only judge distances directly ahead.

Although all domestic animals have a highly sensitive sense of smell, they react in different ways to the smells of slaughterhouses. Smells which cause fear or other negative responses should be taken into consideration when managing animals.

Domestic animals can hear over a greater range of frequencies than humans and are more sensitive to higher frequencies. They tend to be alarmed by constant loud noise and by sudden noises, which may cause them to panic.

### **Distractions and their removal**

Distractions that may cause approaching animals to stop, baulk or turn back should be designed out from new facilities or removed from existing ones. Below are examples of common distractions and methods for eliminating them:

- Reflections on shiny metal or wet floors - move a lamp or change lighting.
- Dark entrances to chutes, races, stun boxes or conveyor restrainers - illuminate with indirect lighting which does not shine directly into the eyes of approaching animals.
- Animals seeing moving people or equipment up ahead - install solid sides on chutes and races or install shields.
- Chains or other loose objects hanging in chutes or on fences - remove them.
- Uneven floors or a sudden drop in floor levels at the entrance to conveyor restrainers – avoid uneven floor surfaces or install a solid false floor under the restrainer to provide an illusion of a solid and continuous walking surface.
- Sounds of air hissing from pneumatic equipment - install silencers or use hydraulic equipment.
- Clanging and banging of metal objects - install rubber stops on gates and other devices to reduce metal to metal contact.
- Air currents from fans or air curtains blowing into the face of animals - redirect or reposition equipment.

## **Article 2**

### **Moving and handling animals**

The following principles should apply to unloading animals, moving them into lairage pens, out of the lairage pens and up to the slaughter point:

- The conditions of the animals should be assessed upon their arrival for any animal welfare problems.
- Injured or sick animals, requiring immediate slaughter, should be killed humanely at the site where they are found.
- The use of force on animals that have little or no room to move should not occur.

- The use of instruments which administer electric shocks (e.g. goads and prods) and their power output should be restricted to that necessary to assist movement of the animals. If such use is necessary, it should be limited to the hindquarters of pigs and large ruminants, and never on sensitive areas such as the eyes, mouth, ears, anogenital region or belly. Such instruments should not be used on horses, sheep and goats of any age, or on calves or piglets, nor on animals that have little or no room to move.
- Performance standards should be established in which numerical scoring is used to evaluate the use of such instruments and to measure the percentage of animals moved with an electric instrument. In properly designed and constructed facilities with competent animal handlers, it should be possible to move 75% or more of the animals without the use of electric instruments.
- Useful and permitted aids for moving animals include panels, flags, plastic paddles, flappers (a length of cane with a short strap of leather or canvas attached), plastic bags and metallic rattles; they should be used in a manner sufficient to encourage and direct movement of the animals but without physical contact with them.
- Shouting or yelling at animals to encourage them to move should not occur as such actions may make the animals agitated, leading to crowding or falling.
- Implements which cause pain and suffering such as large sticks, sticks with sharp ends, metal piping, fencing wire or heavy leather belts should not be used to move animals.
- Animals should be grasped or lifted in a manner which avoids pain or suffering and physical damage (e.g. bruising, fractures, dislocations). In the case of quadrupeds, manual lifting by a person should only be used in young animals or small species, and in a manner appropriate to the species; grasping or lifting such animals only by their wool, hair, feet, neck, ears or tails causing pain or suffering should not be permitted, except in an emergency where animal welfare or human safety may otherwise be compromised.
- Conscious animals should not be thrown or dragged.
- Animals should not be forced to move at a speed greater than their normal walking pace, in order to minimise injury through falling or slipping. Performance standards should be established where numerical scoring of the prevalence of animals slipping or falling is used to evaluate whether animal moving practices and/or facilities should be improved. In properly designed and constructed facilities with competent animal handlers, it should be possible to move 99% of animals without their falling.
- Animal handlers should not force an animal to walk over the top of other animals.
- Under no circumstances should animal handlers resort to violent acts to move animals, such as crushing or breaking animals' tails, grasping animals' eyes or pulling them by their ears. Animal handlers should never apply an injurious object or irritant substance to sensitive areas such as eyes, mouth, ears, anogenital region or belly.

#### **Requirements for animals delivered in containers**

- Containers in which animals are transported should be handled with care, and should not be thrown, dropped or knocked over. Where possible, they should be loaded and unloaded horizontally and mechanically.
- Animals delivered in containers with perforated or flexible bottoms should be unloaded with particular care in order to avoid injury. Where appropriate, animals should be unloaded from the containers individually.

- Animals which have been transported in containers should be slaughtered as soon as possible; mammals and ratites which are not taken directly upon arrival to the place of slaughter should have drinking water available to them from appropriate facilities at all times. Delivery of poultry for slaughter should be scheduled such that they are not deprived of water at the premises for longer than 12 hours. Animals which have not been slaughtered within 12 hours of their arrival should be fed, and should subsequently be given moderate amounts of food at appropriate intervals.

### **Provision relevant to restraining and containing animals**

Provisions relevant to restraining animals for stunning or slaughter without stunning, to help maintain animal welfare include:

- Provision of a non-slip floor
- Avoidance of excessive pressure applied by restraining equipment that causes struggling or vocalisation in animals
- Equipment engineered to reduce noise of air hissing and clanging metal
- Absence of sharp edges in restraining equipment that would harm animals
- Avoidance of jerking or sudden movement of restraining device

Methods of restraint causing avoidable suffering, such as the following, should not be used in conscious animals because they cause severe pain and stress:

- suspending or hoisting animals (other than poultry) by the feet or legs
- indiscriminate and inappropriate use of stunning equipment
- mechanical clamping of an animal's legs or feet (other than shackles used in poultry and ostriches) as the sole method of restraint
- breaking legs, cutting leg tendons or blinding animals in order to immobilise them
- severing the spinal cord, for example using a puntilla or dagger, to immobilise animals
- using electric currents to immobilise animals, except for proper stunning.

### **Article 3**

#### **Lairage design and construction**

The lairage should be designed and constructed to hold an appropriate number of animals in relation to the throughput rate of the slaughterhouse without compromising the welfare of the animals.

In order to permit operations to be conducted as smoothly and efficiently as possible without injury or undue stress to the animals, the lairage areas should be designed and constructed so as to allow the animals to move freely in the required direction, using their behavioural characteristics and without undue penetration of their flight zone.

The following guidelines may help to achieve this.

#### **Design**

- The lairage should be designed to allow a one-way flow of animals from unloading to the point of slaughter, with a minimum of abrupt corners to negotiate.
- In red meat slaughterhouses, pens, passageways and races should be arranged in such a way as to permit inspection of animals at any time, and to permit the removal of sick or injured animals when considered to be appropriate, for which separate appropriate accommodation should be provided.
- Each animal should have room to stand up and lie down and, when confined in a pen, to turn around. The lairage should have sufficient accommodation for the number of animals intended to be held. Drinking water should always be available to the animals, and the method of delivery should be appropriate to the type of animal held. Troughs should be designed and installed in such a way as to minimise the risk of fouling by faeces, without introducing risk of bruising and injury in animals, and should not hinder the movement of animals.
- Holding pens should be rectangular rather than square, to allow as many animals as possible to stand or lie down against a wall. Where feed troughs are provided, they should be sufficient in number and feeding space to allow adequate access of all animals to feed. The feed trough should not hinder the movement of animals.
- Where tethers, ties or individual stalls are used, these should be designed so as not to cause injury or distress especially when the animals are lying down, standing up, drinking and feeding.
- Passageways and races should be either straight or slightly curved, as appropriate to the animal species. Passageways and races should have solid sides, but when there is a double race the shared partition should allow adjacent animals to see each other. For pigs and sheep, passageways should be wide enough to enable two or more animals to walk side by side for as long as possible. At the point where passageways are reduced in width, this should be done by a means which prevents excessive bunching of the animals.
- Animal handlers should be positioned alongside races and passageways on the inside radius of any curve, to take advantage of the natural tendency of animals to circle an intruder. Where one-way gates are used, they should be of a design which avoids bruising. Races should be horizontal but where there is a slope, they should be constructed to allow the free movement of animals without injury.
- There should be a waiting pen, with a level floor and solid sides, between the holding pens and the race leading to the point of stunning or slaughter, to ensure a steady supply of animals for stunning or slaughter and to avoid having animal handlers trying to rush animals from the holding pens. The waiting pen should preferably be circular, but in any case, so designed that animals cannot be trapped or trampled.

- Ramps or lifts should be used for loading and unloading of animals where there is a difference in height or a gap between the floor of the vehicle and the unloading area. The ramp should be well drained, non-slippery and adjustable to facilitate easy movement of animals without causing distress or injury.

### **Construction**

- Lairages should be constructed and maintained so as to provide protection from unfavourable climatic conditions, using strong and resistant materials such as concrete and metal which has been treated to prevent corrosion. Surfaces should be easy to clean. There should be no sharp edges or protuberances which may injure the animals.
- Floors should be well drained and not slippery; they should not cause injury to the animals' feet. Where necessary floors should be insulated or provided with appropriate bedding. Drainage grids should be placed at the sides of pens and passageways and not where animals would have to cross them. Discontinuities or changes in floor patterns or texture which could cause baulking in the movement of animals should be avoided.
- Lairages should be provided with adequate lighting, but care should be taken to avoid harsh lights and shadows, which frighten the animals or affect their movement. The fact that animals will move more readily from a darker area into a well-lit area might be exploited by providing for lighting that can be regulated accordingly.
- Lairages should be well ventilated, and the air flow should be arranged so that odours and draughts do not adversely affect the health and welfare of the animals.
- Care should be taken to protect the animals from excessively or potentially disturbing noises, for example by avoiding the use of noisy hydraulic or pneumatic equipment, and muffling noisy metal equipment by the use of suitable padding, or by minimising the transmission of such noise to the areas where animals are held and slaughtered.
- Where animals are kept in outdoor lairages without natural shelter or shade, they should be protected from the effects of adverse weather conditions.

## **Article 4**

### **Care in lairages**

Animals in lairages should be cared for in accordance with the following guidelines:

- As far as possible established groups of animals should be kept together. Each animal should have enough space to stand up, lie down and turn around. Animals hostile to each other should be separated.
- Where tethers, ties or individual stalls are used they should allow animals to stand up and lie down without causing injury or distress.
- Where bedding is provided, it should be maintained in a condition that minimises risks to the health and safety of the animals, and sufficient should be used so that animals do not become soiled with manure.
- Animals should be kept securely in the lairage and care should be taken to prevent them from escaping and from predators.
- Suitable drinking water should be available to the animals on their arrival and at all times to animals in lairages unless they are to be slaughtered without delay.

- If animals are not to be slaughtered as soon as possible, suitable feed should be available to the animals on arrival and at intervals appropriate to the species. Unweaned animals should be slaughtered as soon as possible.
- In order to prevent heat stress, animals subjected to high temperatures, particularly pigs and poultry, should be cooled by the use of water sprays, fans or other suitable means.
- That lairage area should be well lit in order to enable the animals to see clearly without being dazzled. During the night, the lights should be dimmed.
- The condition and state of health of the animals in a lairage should be inspected at least every morning and evening by a veterinarian or, under the latter's responsibility, by another competent person. Animals which are sick, weak, injured or showing visible signs of distress should be treated or killed immediately.
- Lactating dairy animals should be slaughtered as soon as possible. Dairy animals with obvious udder distension should be milked to minimise udder discomfort.
- Pregnant animals giving birth during the journey or in the lairage should be slaughtered as soon as possible or provided with conditions which are appropriate for suckling and the welfare of the newborn.
- Animals with horns or tusks capable of injuring other animals, if aggressive, should be penned separately.

Recommendations for specific species are described in detail in Articles 6-9.

## **Article 5**

### **Management of foetuses during slaughter of pregnant animals**

The welfare of foetuses during slaughter of pregnant animals needs to be safeguarded.

- Foetuses should not be removed from the uterus sooner than five minutes after the maternal neck or chest cut, to ensure absence of consciousness. A foetal heartbeat will usually still be present and foetal movements may occur at this stage, but these are only a cause for concern if the exposed foetus successfully breathes air.
- If a live mature foetus is removed from the uterus, it should be prevented from inflating its lungs and breathing air (e.g. by clamping the trachea).
- When uterine, placental or foetal tissues, including foetal blood, are not to be collected as part of the post-slaughter processing of pregnant animals, all foetuses should be left inside the unopened uterus until they are dead. When uterine, placental or foetal tissues are to be collected, where practical, foetuses should not be removed from the uterus until at least 15-20 minutes after the maternal neck or chest cut.
- If there is any doubt about consciousness, the foetus should be killed with a captive bolt or a blow to the head with a suitable blunt instrument.

The above guidelines do not refer to foetal rescue. Foetal rescue, the practice of attempting to revive foetuses found alive at evisceration of the dam, should not be attempted during normal commercial slaughter as it may lead to serious welfare complications in the newborn animal. These include impaired brain function resulting from oxygen shortage before rescue is completed, compromised breathing and body heat production because of foetal immaturity, and an increased incidence of infections due to a lack of colostrum.



### Article 6

#### Summary of acceptable handling and restraining methods, and the associated animal welfare issues

	Presentation of animals	Specific procedure	Specific purpose	AW concerns/implications	Key AW requirements	Applicable species
No restraint	Animals are grouped	Group container	Gas stunning	Specific procedure is suitable only for gas stunning	Competent animal handlers in lairage; facilities; stocking density	Pigs, poultry
		In the field	Free bullet	Shooting distance, calibre and ballistics	Operator competence	Deer
		Group stunning pen	Head-only electrical Captive bolt	Uncontrolled movement of animals impedes use of hand operated electrical and mechanical stunning methods	Competent animal handlers in lairage and at stunning point	Pigs, sheep, goats, calves
	Individual animal confinement	Stunning pen/box	Electrical and mechanical stunning methods	Loading of animal; accuracy of stunning method, slippery floor and animal falling down	Competent animal handlers	Cattle, buffalo, sheep, goats, horses, pigs, deer, camelids, ratites
Restraining methods	Head restraint, upright	Halter/ head collar/bridle	Captive bolt Free bullet	Suitable for halter-trained animals; stress in untrained animals	Competent animal handlers	Cattle, buffalo, horses, camelids
	Head restraint, upright	Neck yoke	Captive bolt Electrical-head-only Free bullet Slaughter without stunning	Stress of loading and neck capture; stress of prolonged restraint, horn configuration; unsuitable for fast line speeds, animals struggling and falling due to slippery floor, excessive pressure	Equipment; competent animal handlers, prompt stunning or slaughter	Cattle
	Leg restraint	Single leg tied in flexion (animal standing on 3 legs)	Captive bolt Free bullet	Ineffective control of animal movement, misdirected shots	Competent animal handler	Breeding pigs (boars and sows)

	<b>Presentation of animals</b>	<b>Specific procedure</b>	<b>Specific purpose</b>	<b>AW concerns/implications</b>	<b>Key AW requirements</b>	<b>Applicable species</b>
Restraining methods	Upright restraint	Beak holding	Captive bolt Electrical-head-only	Stress of capture	Sufficient competent animal handlers	Ostriches
		Head restraint in electrical stunning box	Electrical-head-only	Stress of capture and positioning	Competent animal handler	Ostriches
	Holding body upright- manual	Manual restraint	Captive bolt Electrical-head-only Slaughter without stunning	Stress of capture and restraint; accuracy of stunning/slaughter	Competent animal handlers	Sheep, goats, calves, ratites, small camelids, poultry
	Holding body upright mechanical	Mechanical clamp / crush / squeeze/ V-restrainer (static)	Captive bolt Electrical methods Slaughter without stunning	Loading of animal and overriding; excessive pressure	Proper design and operation of equipment	Cattle, buffalo, sheep, goats, deer, pigs, ostriches
	Lateral restraint – manual or mechanical	Restrainer/cradle /cratch	Slaughter without stunning	Stress of restraint	Competent animal handlers	Sheep, goats, calves, camelids, cattle
	Upright restraint mechanical	Mechanical straddle (static)	Slaughter without stunning Electrical methods Captive bolt	Loading of animal and overriding	Competent animal handlers	Cattle, sheep, goats, pigs
	Upright restraint – manual or mechanical	Wing shackling	Electrical	Excessive tension applied prior to stunning	Competent animal handlers	Ostriches

	<b>Presentation of animals</b>	<b>Specific procedure</b>	<b>Specific purpose</b>	<b>AW concerns/implications</b>	<b>Key AW requirements</b>	<b>Applicable species</b>
Restraining and /or conveying methods	Mechanical - upright	V-restrainer	Electrical methods Captive bolt Slaughter without stunning	Loading of animal and overriding; excessive pressure, size mismatch between restrainer and animal	Proper design and operation of equipment	Cattle, calves, sheep, goats, pigs
	Mechanical- upright	Mechanical straddle – band restrainer (moving)	Electrical methods Captive bolt Slaughter without stunning	Loading of animal and overriding, size mismatch between restrainer and animal	Competent animal handlers, proper design and layout of restraint	Cattle, calves, sheep, goats, pigs
	Mechanical - upright	Flat bed/deck Tipped out of containers on to conveyors	Presentation of birds for shackling prior to electrical stunning Gas stunning	Stress and injury due to tipping in dump-module systems height of tipping conscious poultry broken bones and dislocations	Proper design and operation of equipment	Poultry
	Suspension and/or inversion	Poultry shackle	Electrical stunning Slaughter without stunning	Inversion stress; pain from compression on leg bones	Competent animal handlers; proper design and operation of equipment	Poultry
	Suspension and/or inversion	Cone	Electrical – head-only; Captive bolt Slaughter without stunning	Inversion stress	Competent animal handlers; proper design and operation of equipment	Poultry
	Upright restraint	Mechanical leg clamping	Electrical – head-only	Stress of resisting restraint in ostriches	Competent animal handlers; proper equipment design and operation	Ostriches

	Presentation of animals	Specific procedure	Specific purpose	AW concerns/implications	Key AW requirements	Applicable species
Restraining by inversion	Rotating box	Fixed side(s) (e.g. Weinberg)	Slaughter without stunning	Inversion stress; stress of resisting restraint, prolonged restraint. Keep restraint as brief as possible	Proper design and operation of equipment	Cattle
Restraining by inversion		Compressible side(s)	Slaughter without stunning	Inversion stress, stress of resisting restraint, prolonged restraint. Preferable to rotating box with fixed sides; Keep restraint as brief as possible	Proper design and operation of equipment	Cattle
Body restraint	Casting/hobbling	Manual	Mechanical stunning methods Slaughter without stunning	Stress of resisting restraint; animal temperament; bruising. Keep restraint as short as possible	Competent animal handlers	Sheep, goats, calves, small camelids, pigs
Leg restraints		Rope casting	Mechanical stunning methods Slaughter without stunning	Stress of resisting restraint; prolonged restraint, animal temperament; bruising. Keep restraint as short as possible	Competent animal handlers	Cattle, camelids
		Tying of 3 or 4 legs	Mechanical stunning methods Slaughter without stunning	Stress of resisting restraint; prolonged restraint, animal temperament; bruising. Keep restraint as short as possible	Competent animal handlers	Sheep, goats, small camelids, pigs

## Article 7

### Stunning methods

#### Stunning

The competence of the operators, and the appropriateness and effectiveness of the method used for stunning are the responsibility of the management of the slaughterhouse, and should be checked regularly by a competent authority.

Persons carrying out stunning should be properly trained and competent, and should ensure that:

- the animal is adequately restrained,<sup>1</sup>
- animals in restraint are stunned as soon as possible;
- the equipment used for stunning is maintained and operated properly in accordance with the manufacturer's recommendations, in particular with regard to the species and size of the animal;
- the instrument is applied correctly;
- stunned animals are bled out (slaughtered) as soon as possible,
- do not stun animals when slaughter is likely to be delayed.

In addition, such persons should be able to recognise when an animal is not correctly stunned and should take appropriate action.

#### Mechanical stunning

A mechanical device should be applied usually to the front of the head and perpendicular to the bone surface. The following diagrams illustrate the proper application of the device for certain species.

**Cattle**



The optimum position for cattle is at the intersection of two imaginary lines drawn from the rear of the eyes to the opposite horn buds.

### Pigs



The optimum position for pigs is just above the eyes and directing the shot down the line of the spinal chord.

### Sheep

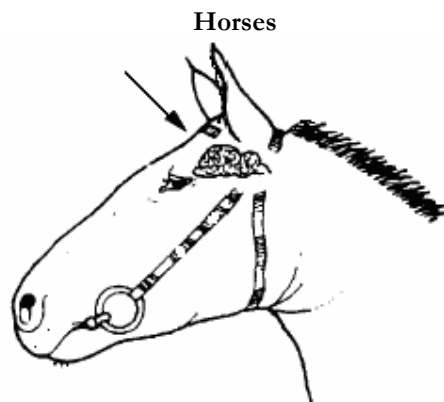


The optimum position for hornless sheep and goats is on the midline, just above the eyes and directing the shot down the line of the spinal chord.

### Goats



The optimum position for heavily horned sheep and horned goats is behind the poll, aiming towards the angle of the jaw.



Place the muzzle at right angles to the frontal surface well above the point where imaginary lines from eye to ear cross.

Signs of correct stunning using a mechanical instrument:

- i) the animal collapses immediately and does not attempt to stand up;
- ii) the body and muscles of the animal become tonic (rigid) immediately after the shot;
- iii) normal rhythmic breathing stops; and
- iv) the eyelid is open with the eyeball facing straight ahead and is not rotated.

### **Electrical stunning**

#### ***a) General***

An electrical device should be applied to the animal in accordance with the following guidelines.

Electrodes should be designed, constructed, maintained and cleaned regularly to ensure that the flow of current is optimal and in accordance to manufacturing specification. They should be placed so that they span the brain. The application of electrical currents which bypass the brain are unacceptable unless the animal has been stunned. The use of a single current leg-to-leg is unacceptable as a stunning method.

If, in addition, it is intended to cause cardiac arrest, the electrodes should either span the brain and immediately thereafter the heart, on the condition that it has been ascertained that the animal is adequately stunned, or span brain and heart simultaneously.

Electrical stunning equipment should not be applied on animals as a means of guidance, movement, restraint or immobilisation, and shall not deliver any shock to the animal before the actual stunning or killing.

Electrical stunning apparatus should be tested prior to application on animals using appropriate resistors or dummy loads to ensure the power output is adequate to stun animals.

The apparatus should incorporate a device which monitors and displays stunning current delivered to the animals

Appropriate measures, such as removing excess wool or wetting the skin only at the point of contact can be taken to minimise impedance of the skin and facilitate effective stunning.

The stunning apparatus requires for electrical stunning should be provided with adequate power to achieve continuously the minimum current level recommended for stunning as indicate in the table below:

Species	Minimum current levels
Cattle	1.5 amps
Calves	1.0 amps
Pigs	1.25 amps
Sheep & Goats	0.5 amps
Ostriches	0.4 amps

In all cases, the correct current level shall be attained within one second of the initiation of stun and maintained at least for between one and three seconds and in accordance with the manufacturer's instructions.

***b) Electrical stunning of birds using a waterbath***

In the case of birds suspended on a moving line, measures should be taken to ensure that the birds are not wing flapping at the entrance of the stunner. The birds should be secure in their shackle, but there should not be undue pressure on their shanks.

Waterbaths for poultry should be adequate in size and depth for the type of bird being slaughtered, and their height should be adjustable to allow for the head of each bird to be immersed. The electrode immersed in the bath should extend the full length of the waterbath. Birds should be immersed in the bath up to the base of their wings.

The waterbath should be designed and maintained in such a way that when the shackles pass over the water they are in continuous contact with the earthed rubbing bar.

The control box for the waterbath stunner should incorporate an ammeter which displays the total current flowing through the birds.

The shackle-to-leg contact should be wetted preferably before the birds are inserted in the shackles. In order to improve electrical conductivity of the water it is recommended that salt be added in the waterbath as necessary.

Birds should receive the current for at least 4 seconds.

Using waterbaths, birds are stunned in groups and different birds will have different impedances. The voltage should be adjusted so that the total current is the required current per bird as shown in the table hereafter, multiplied by the number of birds in the waterbath at the same time.



The following values have been found to be satisfactory when employing a 50 Hertz sinusoidal alternating current.

Species	Current (milliamperes per bird)
Broilers	120
Layers (spent hens)	120
Turkeys	150
Ducks and Geese	130

While a lower current may also be satisfactory, the current shall in any case be such as to ensure that unconsciousness occurs immediately and lasts until the bird has been killed by cardiac arrest or by bleeding. When higher electrical frequencies are used, higher currents may be required.

Every effort shall be made to ensure that no conscious or live birds enter the scalding tank.

In the case of automatic systems, until fail-safe systems of stunning and bleeding have been introduced, a manual back-up system should be in place to ensure that any birds which have missed the waterbath stunner and/or the automatic neck-cutter are immediately stunned and/or humanely killed, and they are dead before entering scald tank.

To lessen the number of unstunned birds, reaching neck cutters, steps should be taken to ensure that small birds do not go on the line amongst bigger birds and that these small birds are stunned separately.

## Gas stunning

### *a) Stunning of pigs by exposure to carbon dioxide (CO<sub>2</sub>)*

The concentration of CO<sub>2</sub> for stunning should be preferably 90% by volume but in any case no less than 80% by volume. After entering the stunning chamber the animals should be conveyed to the point of maximum concentration of the gas and be kept until they are dead or brought into a state of insensibility which lasts until death occur due to bleeding. Ideally, pigs should be exposed to this concentration of CO<sub>2</sub> for three minutes.

In any case, the concentration of the gas should be such that it minimises as far as possible all stress of the animal prior to loss of consciousness.

The chamber in which animals are exposed to CO<sub>2</sub> and the equipment used for conveying them through it shall be designed, constructed and maintained in such a way as to avoid injury or unnecessary stress to the animals. The animal density within the chamber should be such to avoid stacking animals on top of each others.

The conveyor and the chamber shall be adequately lit to allow the animals to see their surroundings and if possible, each other.

It should be possible to inspect the CO<sub>2</sub> chamber whilst it is in use, and to have access to the animals in emergency cases.

The chamber shall be equipped to continuously measure and display register at the point of stunning the CO<sub>2</sub> concentration and the time of exposure, and to give a clearly visible and audible warning if the concentration of CO<sub>2</sub> falls below the required level.

***b) Inert gas mixtures for stunning pigs (under development)***

Inhalation of high concentration of carbon dioxide is aversive and can be distressing to animals. Therefore, the use of non-aversive gas mixtures is being developed.

Gas mixtures:

- i) a maximum of 2% by volume of oxygen in argon, nitrogen or other inert gases, or
- ii) to a maximum of 30% by volume of carbon dioxide and a maximum of 2% by volume of oxygen in mixtures with carbon dioxide and argon, nitrogen or other inert gases.

Exposure time to the gas mixtures should be sufficient to ensure that no pigs regain consciousness before death supervenes through bleeding or cardiac arrest is induced.

***c) Gas stunning of poultry***

The main objective of gas stunning is to avoid the pain and suffering associated with shackling conscious poultry under water bath stunning and killing systems. Therefore, gas stunning should be limited to birds contained in crates or on conveyors only. The gas mixture should be non-aversive to poultry.

Gas stunning of poultry in their transport containers will eliminate the need for live bird handling at the processing plant and all the problems associated with the electrical stunning.

Gas stunning poultry on a conveyor eliminates the problems associated with the electrical water bath stunning.

Live poultry shall be conveyed into the gas mixtures either in transport crates or on conveyor belts.

- i) Gas mixtures used for stunning poultry
  - Minimum of 2 min exposure to 40% carbon dioxide, 30% oxygen and 30% nitrogen, followed by a minimum of 1 min exposure to 80% carbon dioxide in air; or
  - Minimum of 2 min exposure to any mixture of argon, nitrogen or other inert gases with atmospheric air and carbon dioxide, provided that the carbon dioxide concentration does not exceed 30% by volume and the residual oxygen concentration does not exceed 2% by volume; or
  - Minimum of 2 min exposure to argon, nitrogen, other inert gases or any mixture of these gases in atmospheric air with a maximum of 2% residual oxygen by volume; or
  - Minimum of 2 minutes exposure to a minimum of 55% carbon dioxide in air.
- ii) Requirements for effective use:
  - Compressed gases should be vaporised prior to administration into the chamber.
  - Under no circumstances, should solid gases with freezing temperatures enter the chamber.
  - Gas mixtures should be humidified.
  - Appropriate gas concentrations should be monitored and displayed continuously at the level of the birds inside the chamber.

Under no circumstances should birds exposed to gas mixtures be allowed to regain consciousness. If necessary, the exposure time should be extended.

### **Bleeding**

From the point of view of animal welfare, animals which are stunned with a reversible method should be bled without delay and in any case within the following time limits:

<b>Stunning method</b>	<b>Maximum delay for bleeding to be started</b>
Electrical methods and non penetrating bolt	20 seconds
CO <sub>2</sub>	60 seconds (after leaving the chamber)

All animals should be bled by incising both carotid arteries, or the vessels from which they arise (e.g. chest stick). However, when the stunning method used causes cardiac arrest, the incision of all of these vessels is not necessary from the point of animal welfare.

It should be possible for staff to observe, inspect and access the animals throughout the bleeding period. Any animal showing signs of recovering consciousness should be restunned.

After incision of the blood vessels, no scalding carcass treatment or dressing procedures should be performed on the animals for at least thirty seconds, or in any case until all brain-stem reflexes have ceased.

### Article 8

#### Summary of acceptable stunning methods and the associated animal welfare issues

Method	Specific method	AW concerns/implications	Key AW requirements applicable	Species	Comment
Mechanical	Free bullet	Inaccurate targeting and inappropriate ballistics	Accuracy; head shots only correct ballistics	Cattle, calves, buffalo, deer, horses, pigs (boars and sows)	Personnel safety
	Captive bolt - penetrating	Inaccurate targeting, velocity and diameter of bolt	Competent operation and maintenance of equipment; restraint; accuracy	Cattle, calves, buffalo, sheep, goats, deer, horses, pigs, camelids, ratites	(Unsuitable for specimen collection from TSE suspects). A back-up gun should be available in the event of an ineffective shot
	Captive bolt - non-penetrating	Inaccurate targeting, velocity of bolt, potentially higher failure rate than penetrating captive bolt	Competent operation and maintenance of equipment; restraint; accuracy	Cattle, calves, sheep, goats, deer, pigs, camelids, ratites	Presently available devices are not recommended for young bulls and animals with thick skull
	Manual percussive blow	Inaccurate targeting; insufficient power; size of instrument	Competent animal handlers; restraint; accuracy. Not recommended for general use	Young and small mammals, ostriches and poultry	Mechanical devices potentially more reliable. Where manual percussive blow is used, unconsciousness should be achieved with single sharp blow delivered to central skull bones
Electrical	Split application: 1. across head then head to chest; 2. across head then across chest	Accidental pre-stun electric shocks; electrode positioning; application of a current to the body while animal conscious; inadequate current and voltage	Competent operation and maintenance of equipment; restraint; accuracy	Cattle, calves, sheep, goats and pigs, ratites and poultry	Systems involving repeated application of head-only or head-to-leg with short current durations (<1 second) in the first application should not be used. Where cardiac arrest occurs, the carcass may not be suitable for Halal

Method	Specific method	AW concerns/implications	Key AW requirements applicable	Species	Comment
Electrical	Single application: 1. head only; 2. head to body; 3. head to leg	Accidental pre-stun electric shocks; inadequate current and voltage; wrong electrode positioning; recovery of consciousness	Competent operation and maintenance of equipment; restraint; accuracy	Cattle, calves, sheep, goats, pigs, ratites, poultry	Where cardiac arrest occurs, the carcass may not be suitable for Halal
	Waterbath	Restraint, accidental pre-stun electric shocks; inadequate current and voltage; recovery of consciousness	Competent operation and maintenance of equipment	Poultry only	Where cardiac arrest occurs, the carcass may not be suitable for Halal
Gaseous	CO <sub>2</sub> air/O <sub>2</sub> mixture; CO <sub>2</sub> inert gas mixture	Aversiveness of high CO <sub>2</sub> ; respiratory distress; inadequate exposure	Concentration; duration of exposure; design, maintenance and operation of equipment; stocking density management	Pigs, poultry	Gaseous methods may not be suitable for Halal
	Inert gases	Recovery of consciousness	Concentration; duration of exposure; design, maintenance and operation of equipment; stocking density management	Pigs, poultry	Gaseous methods may not be suitable for Halal

**Article 9**  
**Summary of acceptable slaughter methods, and the associated animal welfare issues**

<b>Slaughter methods</b>	<b>Specific method</b>	<b>AW concerns / implications</b>	<b>Key requirements</b>	<b>Species</b>	<b>Comments</b>
Bleeding out by severance of blood vessels in the neck without stunning	Full frontal cutting across the throat	Failure to cut both common carotid arteries; occlusion of cut arteries	A very sharp blade or knife, of sufficient length so that the point of the knife remains outside the incision during the cut; the point of the knife should not be used to make the incision. An incision which does not close over the knife during the throat cut.	Cattle, buffalo, horses, camelids, sheep, goats, poultry, ratites	This method is applicable to Halal and Kosher for relevant species
Bleeding with prior stunning	Neck stab followed by forward cut	Ineffective stunning; failure to cut both common carotid arteries; impaired blood flow; delay in cutting after reversible stunning	Prompt and accurate cutting;	Camelids, sheep, goats, poultry, ratites	
	Neck stab alone	Ineffective stunning; failure to cut both common carotid arteries; impaired blood flow; delay in cutting after reversible stunning	Prompt and accurate cutting	Camelids, sheep, goats, poultry, ratites	
	Chest stick into major arteries or hollow-tube knife into heart	Ineffective stunning; Inadequate size of stick wound inadequate length of sticking knife; delay in sticking after reversible stunning	Prompt and accurate sticking;	Cattle, sheep, goats, pigs	
	Neck skin cut followed by severance of vessels in the neck	Ineffective stunning; Inadequate size of stick wound; Inadequate length of sticking knife; delay in sticking after reversible stunning	Prompt and accurate cutting of vessels	Cattle	

Slaughter methods	Specific method	AW concerns / implications	Key requirements	Species	Comments
Bleeding with prior stunning	Automated mechanical cutting	Ineffective stunning; failure to cut and misplaced cuts. Recovery of consciousness following reversible stunning systems	Design, maintenance and operation of equipment; accuracy of cut; manual back-up	Poultry only	
	Manual neck cut on one side	Ineffective stunning; recovery of consciousness following reversible stunning systems	Prior non-reversible stunning	Poultry only	N.B. slow induction of unconsciousness under slaughter without stunning
	Oral cut	Ineffective stunning; recovery of consciousness following reversible stunning systems	Prior non-reversible stunning	Poultry only	N.B. slow induction of unconsciousness in non-stun systems
Other methods without stunning	Decapitation with a sharp knife	Pain due to loss of consciousness not being immediate		Sheep, goats, poultry	This method is only applicable to Jhatka
	Manual neck dislocation and decapitation	Pain due to loss of consciousness not being immediate; difficult to achieve in large birds	Neck dislocation should be performed in one stretch to sever the spinal cord	Poultry only	Slaughter by neck dislocation should be performed in one stretch to sever the spinal cord
Cardiac arrest in a waterbath electric stunner	Bleeding by evisceration		Induction of cardiac arrest	Quail	
	Bleeding by neck cutting			Poultry	

## Article 10

### Methods, procedures or practices unacceptable on animal welfare grounds

- The restraining methods through immobilisation by injury like ‘puntilla’, breaking legs and ‘leg tendon cutting’, cause severe pain and stress in animals. Those methods are not acceptable in any species.
- The use of electrical stunning method with single application leg to leg is ineffective and unacceptable in any species. The electrocution in this way is likely to be painful. The animal welfare concerns are:
  - accidental pre-stun electric shocks;
  - inadequate current and voltage;
  - wrong electrode positioning;
  - recovery of consciousness.
- The slaughter method of brain stem severance by piercing through the eye socket or skull bone is not acceptable in any species except fish.